

NOTES CONTINUED FROM SHEET 1 ZONE 60

F) REPEAT STEPS (C) THRU (E) UNTIL THE REQUIRED CLEARANCE IS OBTAINED.

G)  REMOVE QUILL ASSY FROM THE TRANSMISSION (REF. NOTE 8D/E) AND INSTALL M83248/1-248 O-RING, MIL-S-8802 SEALANT AND MASTINOX 685K CORROSION PREVENTIVE COMPOUND ON THE TRANSMISSION AND/OR QUILL ASSY PER DRAWING INSTRUCTIONS.

H) REINSERT THE QUILL ASSY INTO THE TRANSMISSION AND COMPLETE ALL OTHER QUILL INSTALLATION OPERATIONS.
(SEE SHEET 2 FOR -01 & -39 INSTALLATION)

I) INSTALL BRACKET P/N 205-040-114-001 AS PER INSTALLATION VIEW A-A SHEET 2A ZONE 2B.

J) FOLLOWING INSTALLATION OF THE 212-040-703 (-39) & 412-040-703 (-01) QUILL ASSY, REF., CONFIRM THE EXISTENCE OF BACKLASH BETWEEN THE 212-040-702 (-39) & 412-030-310 (-01) PINION AND THE 204-040-701 (-39) & 412-040-701 (-01) GEAR WITHIN THE TRANSMISSION BY ROTATING (ROCKING) THE PIN BACK AND FORTH BY MEANS OF ITS SPLINED OUTPUT SHAFT IN THE LOWER ACCESSORY DRIVE PAD. THE AMOUNT OF BACKLASH NEED NOT BE MEASURED.

 10) INSTALL -21 TROUGH REF. AS FOLLOWS:

- CUT AND REMOVE EXISTING TROUGH PER DIMENSIONS SHOWN.
- PRO-SEAL AND TACK -03, -05, AND -07 NUTPLATE STRIP ASSY. ONTO EXISTING TROUGH EDGE AS SHOWN.
- MATCH DRILL -21 TROUGH TO (INSTALLED) -03, -05, AND -07 ASSY. 31 PLACES.
- INSTALL -37 ASSY USING MS27039-1-08 SCREWS & AN960PD10L WASHER (5 PL) AND VIEW C-C WHEN APPLICABLE.
- ATTACH -21 TROUGH TO ACFT USING AW5251OR8 SCREW 31 PL. REF.
- APPLY AB 890 PROSEAL TO PLATENUTS ON -03, -05, & -07 ASSY AND EDGES OF MODIFICATION TO PREVENT MOISTURE LEAKAGE.

 11) REF. WIRE DIAGRAM 400 AMP GENTERATOR, B23-12000. (PREMIER)

 12) SAFETY WIRE PER MS33540 AS APPLICABLE.

 13) BEFORE RIVETING ASSY, MUST BE PERFORMED TO GENERATOR! REINSTALL PROTECTIVE BACKING BEFORE INSTALLATION. CAUTION::: NO BURRS / SCREEN MUST NOT INTERFERE WITH INTERNALS OF GENERATOR!!

 14)  PRIOR TO INSTALLATION OF SET SCREW: PREPARE SET SCREW AND THREADED HOLE IN CASE. APPLY A THIN COAT OF MIL-S-8802 SEALANT TO THE THREADED PORTION OF SET SCREW ONLY. NO SEALANT SHALL BE PRESENT ON POINT OF THE SET SCREW OR IN THREADED HOLE PRIOR TO INSTALLATION OF THE SET SCREW. AFTER INSTALLATION OF SET SCREW. INSURE THAT NO SEALANT IS PRESENT ON ADJACENT SURFACES OR IS PROTRUDING FROM THREADED HOLE.

 15) DO NOT EXPOSE SEALANT-COATED PARTS TO OIL FOR 24 HOURS AFTER SEALANT HAS BEEN APPLIED IF CURED AT ROOM TEMPERATURE. CURING MAY BE EXPEDITED BY HEATING AT 120 DEGREES F +/- 10 DEGREES F FOR (8) HOURS. AFTER WHICH TIME PARTS MAY BE EXPOSED TO OIL.

 16) INSTALLATION OF MS51964-97 SET SCREW ONLY APPLIES TO 212 SHIP SERIAL NUMBERS 30680 THRU 30939.

 17)  APPLY A THIN EVEN FILM OF MASTINOX 685K CORROSION PREVENTIVE COMPOUND TO INDICATED AREAS OF THE TRANSMISSION QUILL PORT AND THE QUILL ASSEMBLY IMMEDIATELY PRIOR TO INSTALLATION OF THE QUILL. THIN COMPOUND AS REQUIRED WITH MEK TO OBTAIN A BRUSHABLE CONSISTENCY.

 18) BEFORE APPLYING FRESH CORROSION PREVENTIVE COMPOUND IN ACCORDANCE WITH NOTE 17. THE BORE AND FACE OF THE TRANSMISSION ACCESSORY QUILL PORT MUST BE COMPLETELY CLEANED OF ANY SEALANT, PAINT, AND CORROSION PREVENTIVE COMPOUND RESIDUE.

 19)  AFTER INSTALLATION OF QUILL ASSY., APPLY A SMALL BEAD OF MIL-S-8802 SEALANT AT THE TRANSMISSION TO QUILL INTERFACE.

- 20 △ 15 AFTER ASSEMBLING QUILL ASSY. INTO TRANSMISSION ASSY., COAT SURFACE OF PLUG WITH MIL-S-8802 SEALANT. INSTALL PLUG AND APPLY A BEAD OF MIL-S-8802 SEALANT AROUND PROTRUDING O.D. OF PLUG.
- 21 △ CAUTION: THIS KIT MUST NOT BE INSTALLED IN 212-040-001 OR 412-040-002 TRANSMISSION ASSEMBLIES.
- 22 △ CAUTION: THE 412-040-703 QUILL ASSY. IS A LOOK-ALIKE PART. ENSURE THAT THE 412-040-310 GEAR HAS FOUR HOLES IN ITS WEB. AS SHOWN IN VIEW D-D SHEET 2A.
- 23 △ AFTER COMPLETION OF QUILL INSTALLATION REPLACE DECAL AS SHOWN IN VIEW E SHEET 2A ZONE 5A.
- 24 △ THE -41 SPLICE REF. IS FOR PREMIER HOIST INSTALLATION ONLY, AND IS NOT INSTALLED WITH STANDARD GENERATOR/PUMP QUILL INSTALLATION.

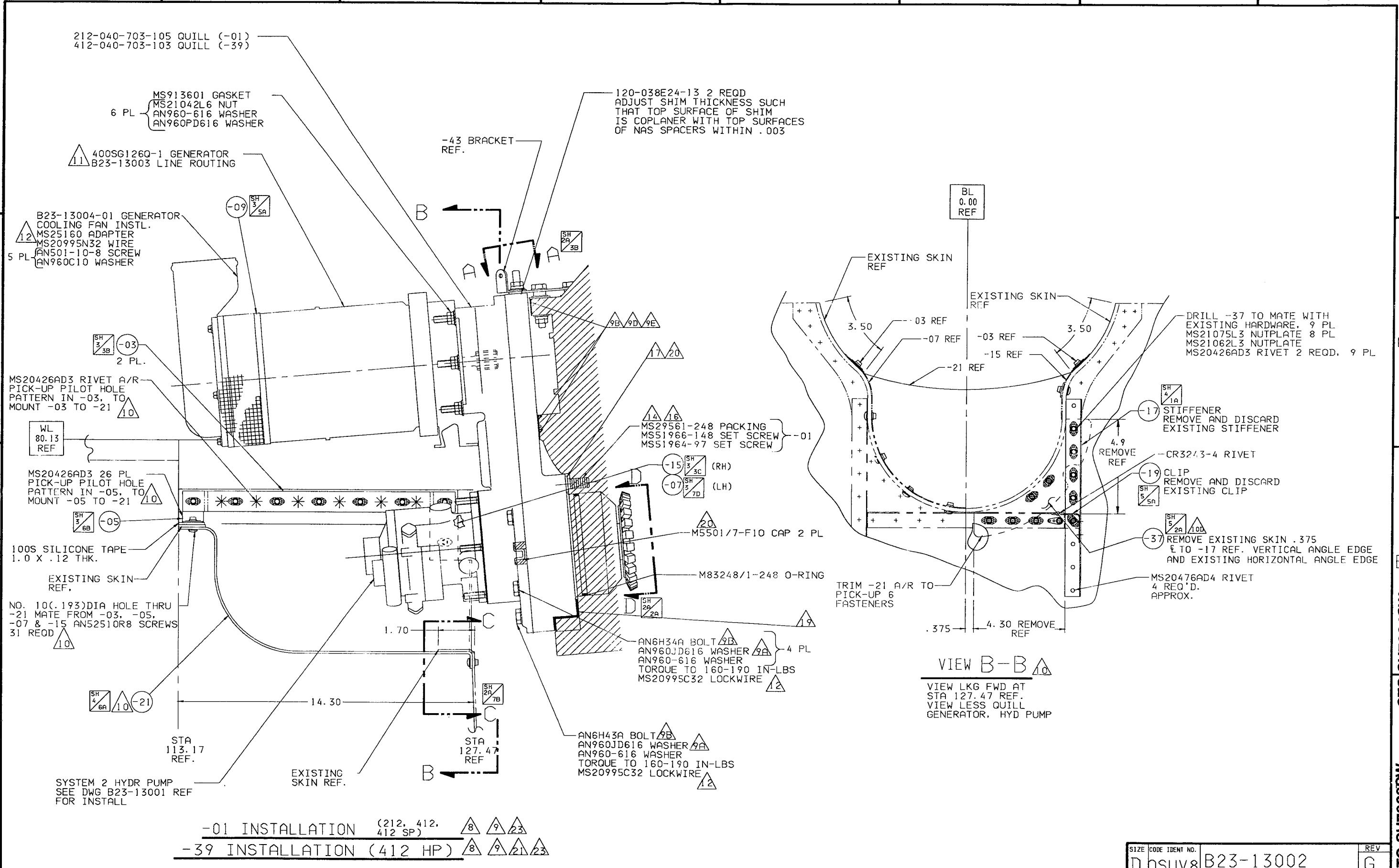
REF				REF	B23-13004-01		GENERATOR COOLING FAN INSTL.	PREMIER			
REF				REF	B23-13003		GENERATOR LINE ROUTING INSTALLATION	PREMIER			
REF				REF	B23-13002-75		STRAP	PREMIER			
REF				REF	B23-13001		MOD SYS 2 HYD PUMP INSTL	PREMIER			
REF				REF	B23-12000		WIRE DIAGRAM 400 AMP GEN.	PREMIER			
A/R				A/R	965073/3623-03		LABLE TAPE	GENERAL BINDING			
1					412-040-703-103		QUILL	BHT			
REF				REF	400SG126Q-1		GENERATOR	AIRCRAFT PARTS CORP			
1				1	212-075-033-103		DECAL	BHT			
1				1	212-040-199-001		WASHER	BHT			
				1	212-040-703-105		QUILL	BHT			
1				1	205-040-114-001		BRACE	BHT			
A/R				A/R	120-038E24-13		SHIM	BHT			
A/R				A/R	100S		SILICONE TAPE 1.0 x .12 THK	CHR Industries			
REF				REF	T101338		JACKSCREW SET	BHT			
A/R				A/R	MIL-S-8802		SEALENT	BHT			
A/R				A/R	MASTINOX 685K		CORROSION PREVENTIVE COMPOUND	AMERICAN EUROCOPTER			
1				1	CR3243-4		RIVET	CHERRY			
		A/R	A/R	A/R	AB 890		PORSEAL	HYSOL			
4				4	NAS43HT6-25		SPACER				
1				1	M83248/1-248		O-RING				
2				2	M5501/7-F10		CAP				
1				1	MS913601		GASKET				
				1	MS51966-148		SET SCREW				
				1	MS51964-97		SET SCREW		16		
				1	MS29561-248		PACKING				
5				5	MS27039-1-08		SCREW				
1				1	MS25160		ADAPTER				
8	2	1	4	6	7	8	MS21075L3	NUTPLATE			
		1					MS21069L3	NUTPLATE			
1							MS21062L3	NUTPLATE			
12					12		MS21042L6	NUT			
A/R				A/R	MS20995N32		WIRE				
A/R				A/R	MS20995C32		WIRE				
A/R	A/R	A/R	A/R	A/R	A/R	A/R	MS20426AD3	RIVET			
A/R							A/R	MS20426AD4	RIVET		
QTY PER	QTY PER	PART NO.	DESCRIPTION	SPECIFICATION	CODE IDENT NO.	ITEM NO.					
-39	-37	-15	-09	-07	-05	-03		PARTS LIST			

NOTES CONTINUED ZONE 5D

SIZE	CODE	IDENT NO.	REV.
D	OSUV8	B23-13002	G
GEN/PUMP QUILL INSTALLATION			SHEET 1A OF 5

8 7 6 5 4 3 2 1

212-040-703-105 QUILL (-01)
412-040-703-103 QUILL (-39)

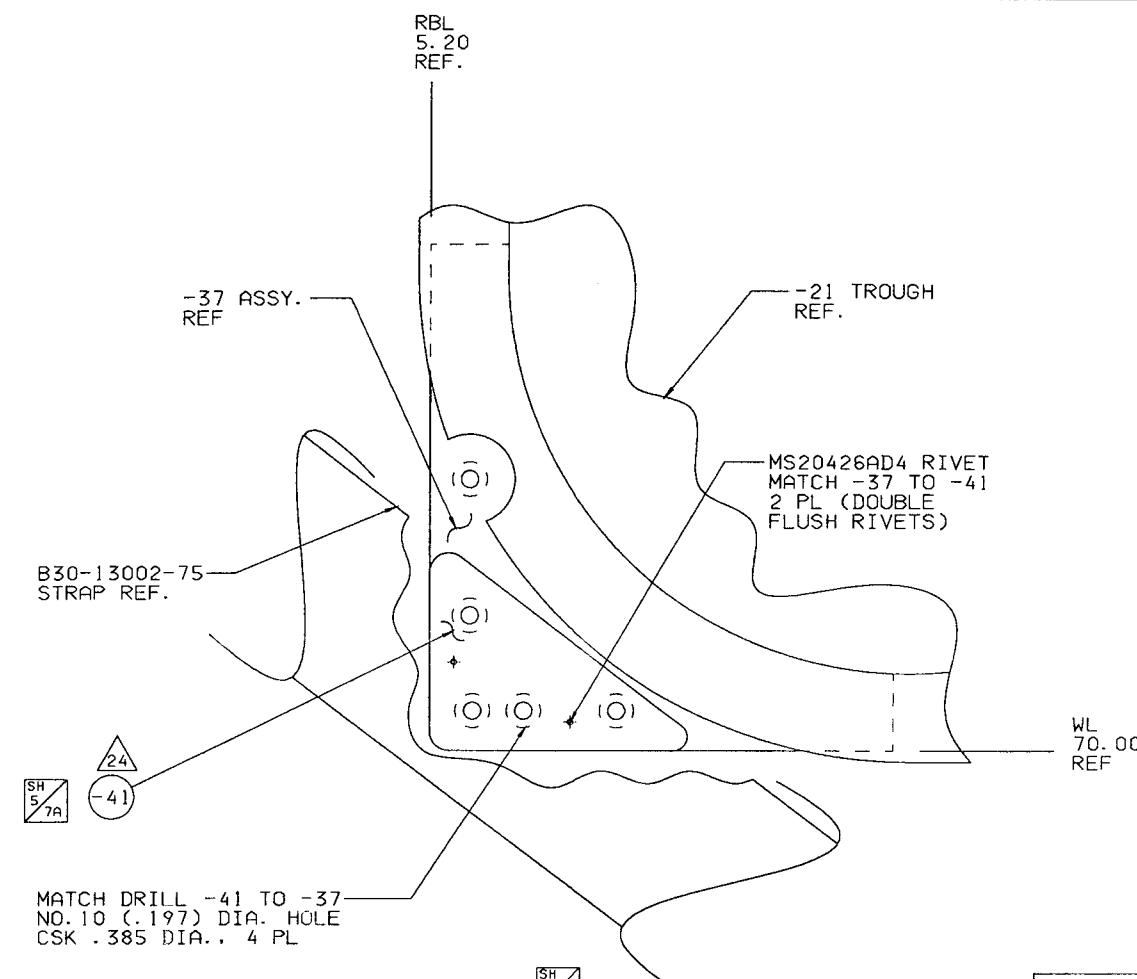


SIZE CODE IDENT NO.
D DSUV8 B23-13002
GEN/PUMP QUILL INSTALLATION

STC SH7923SW STC SH7934SW

8 7 6 5 4 3 2 1

STC'd PRINT B2313002, 02 ORIGINAL

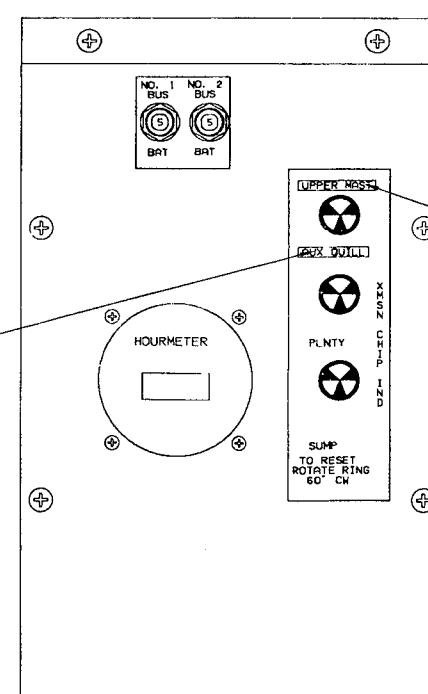


VIEW C-C

VIEW LKG AFT
@ STA 127.47 REF
(ALT VIEW FOR
PREMIER HOIST INSTL)

REMOVE EXISTING MAST LABEL TAPE
AND REPLACE WITH LABEL SHOWN
CROIX TYPE
FONT: HELVETICA
MEDIUM 12 POINT
WHITE ON CLEAR

WL
22.00
REF.

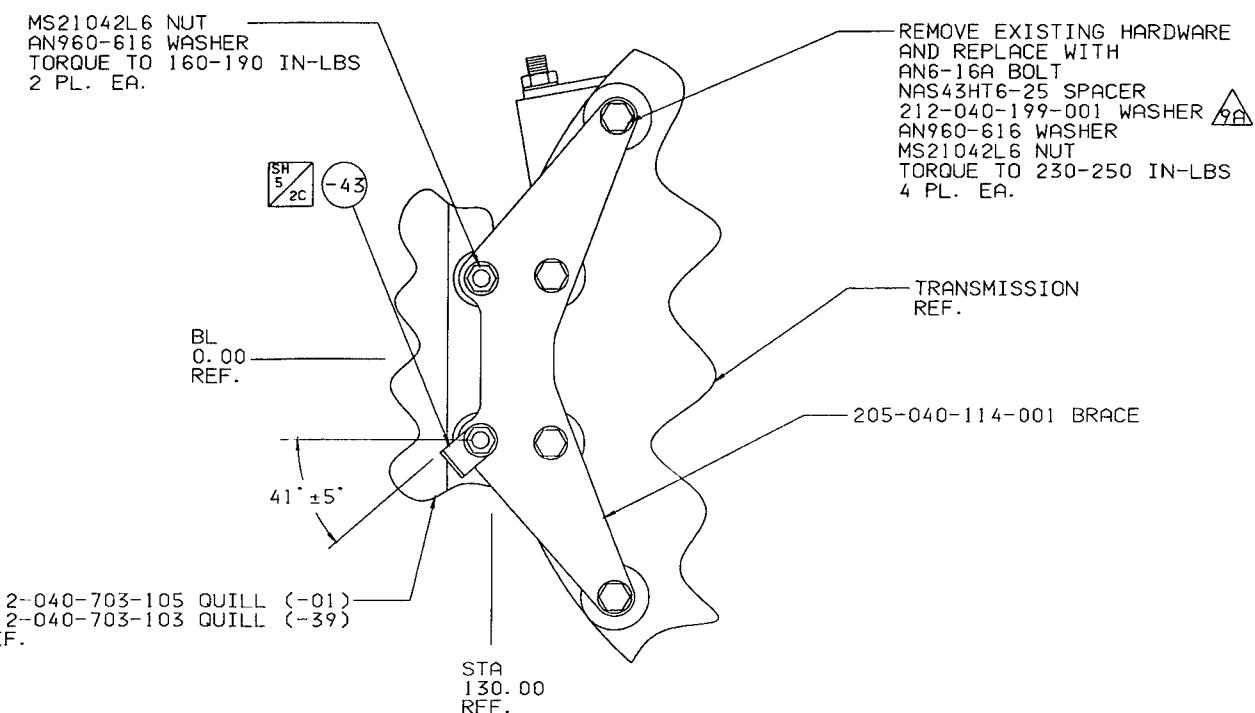


VIEW E

VIEW LKG INBD
@ RBL 8.00 REF

STA
37.00
REF.

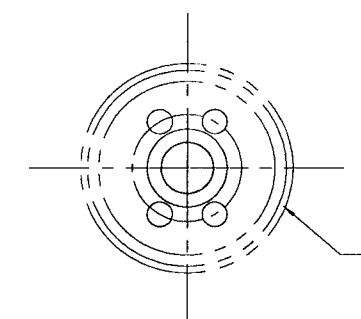
FWD



VIEW A-A

VIEW LKG DOWN
@ WL 127.47 REF

REMOVE EXISTING [UPPER] LABEL TAPE
AND REPLACE WITH LABEL SHOWN
CROIX TYPE
FONT: HELVETICA
MEDIUM 12 POINT
WHITE ON CLEAR



VIEW D-D

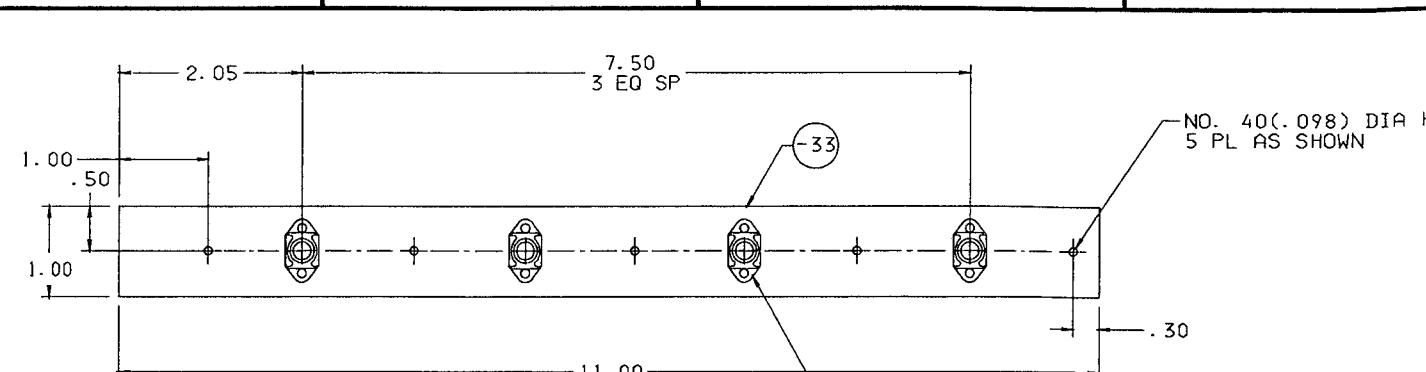
VIEW LKG FWD
@ WL 132.00 REF.

SIZE CODE IDENT NO.
D OSUV8 B23-13002

REV
G

GEN/PUMP QUILL INSTALLATION

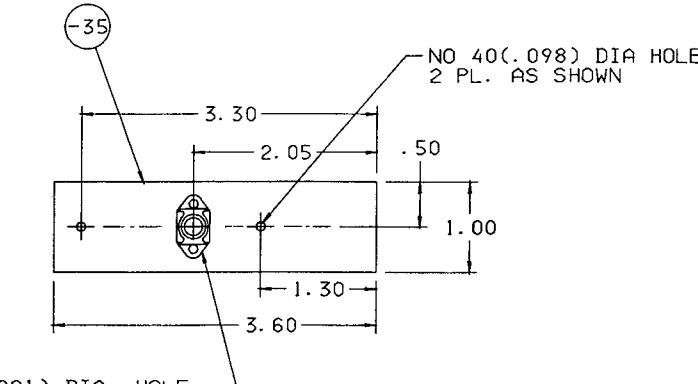
SHEET 2A OF 5



-07 ASS

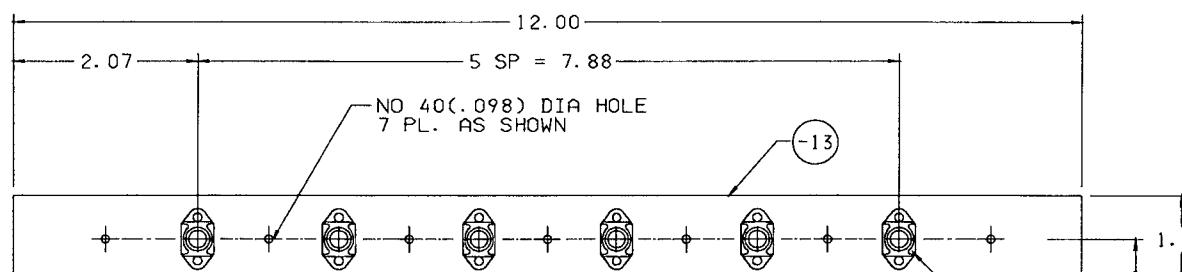
MATL: .050 THK ALUM 2024-
QQ-A-250/4

NO. 7(.201) DIA. HOLE
MS21075L3 NUTPLATE
CSK 100° F.S.
MS20426AD3 RIVET (2
4 PL. EA.



NO. 7(.201) DIA. HOLE
MS21075L3 NUTPLATE
CSK 100° F.S.
MS20426AD3 RIVET (2)

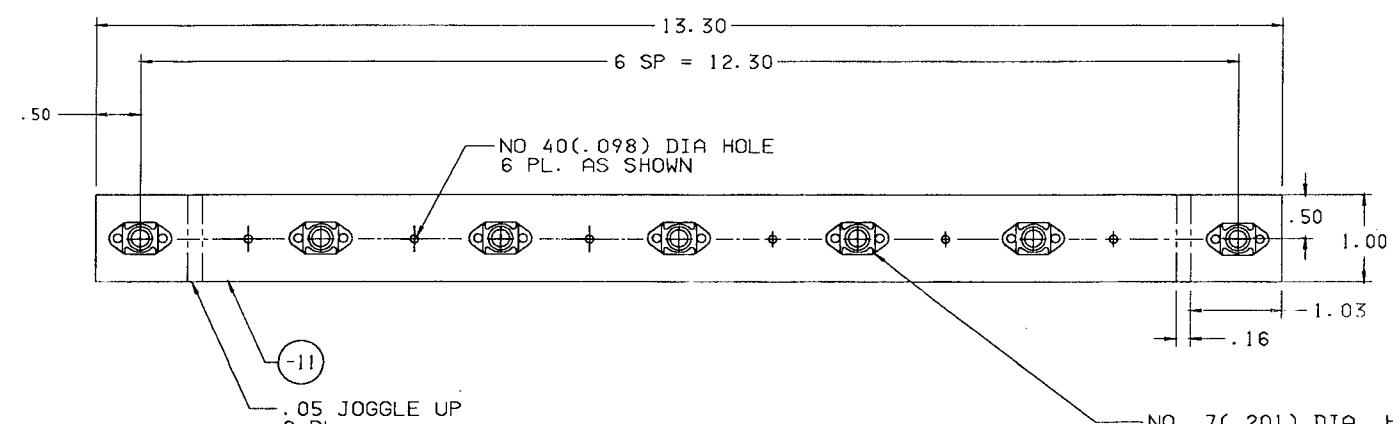
-15 ASSY SH
2/5B
MATL: .050 THK ALUM 2024-T3
QQ-A-250/4



-05 NUTPLATE STRIP ASSY

MATL: .050 THK ALUM 2024-T
QQ-A-250/4

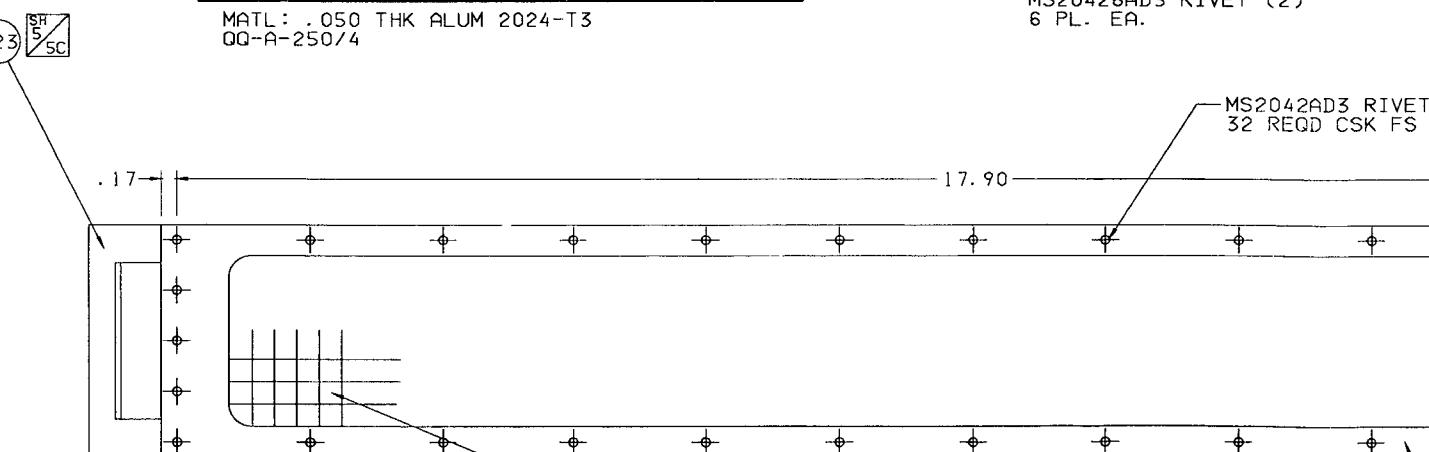
NO. 7(.201) DIA. HC
MS21075L3 NUTPLATE
CSK 100 F.S.
MS20426AD3 RIVET (2
6 PL. EA.



-03 NUTPLATE STRIP ASSY

MATL: .050 THK ALUM 2024-T3
22-0-25044

-NO. 7(.201) DIA. HOLE
MS21075L3 NUTPLATE
CSK 100 F.S.
MS20426AD3 RIVET (2)
7 PL. EA.



-23 REF
23 REF
25 REF
29
.25 WIRE CLOTH
SAME DIMENSION AS -2
(SEE SHEET 4 ZONE 5C)

-09 ASSY

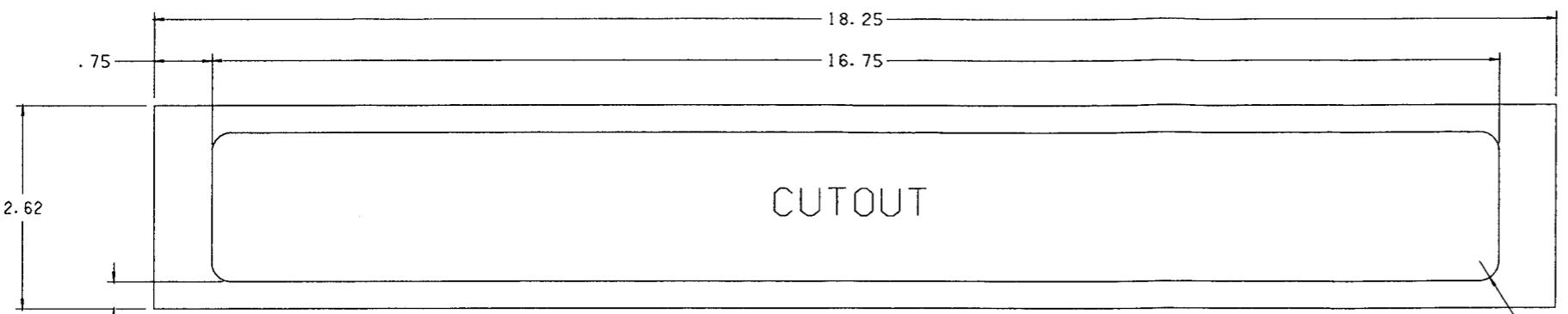
REMOVE EXISTING NUT
REPLACE WITH
MS21069L3 NUTPLATE
MS20426AD3 RIVET (2)

SIZE	CODE IDENT NO.
D	bsUV8 B23-13002

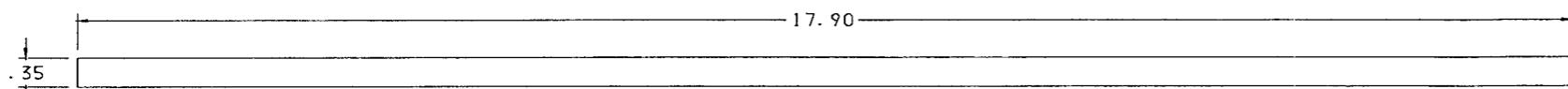
STC SH7923SW STC SH7934SW

STC'd PRINT B2313002.03 ORIGINAL

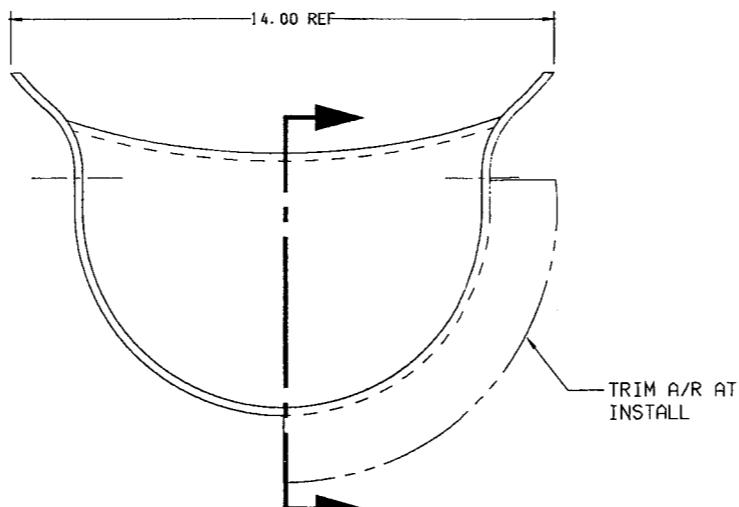
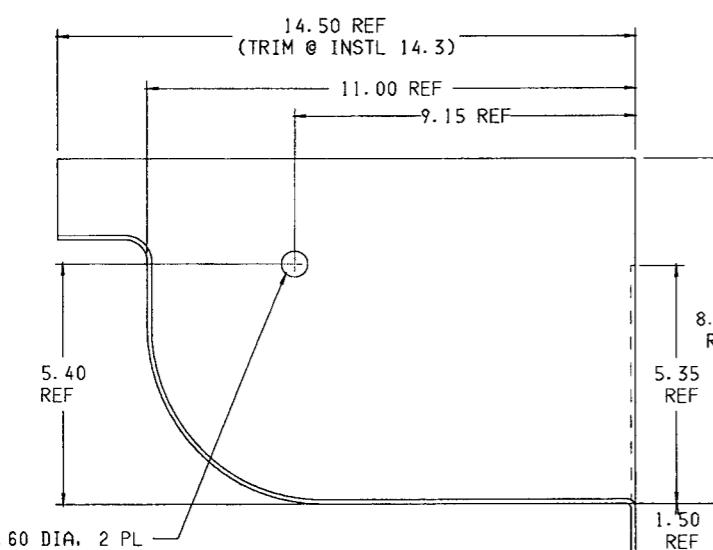
8 7 6 5 4 3 2 1



-25 DOUBLER 
MAT'L.: .050 THK 2024-T3
QQ-A-250/4

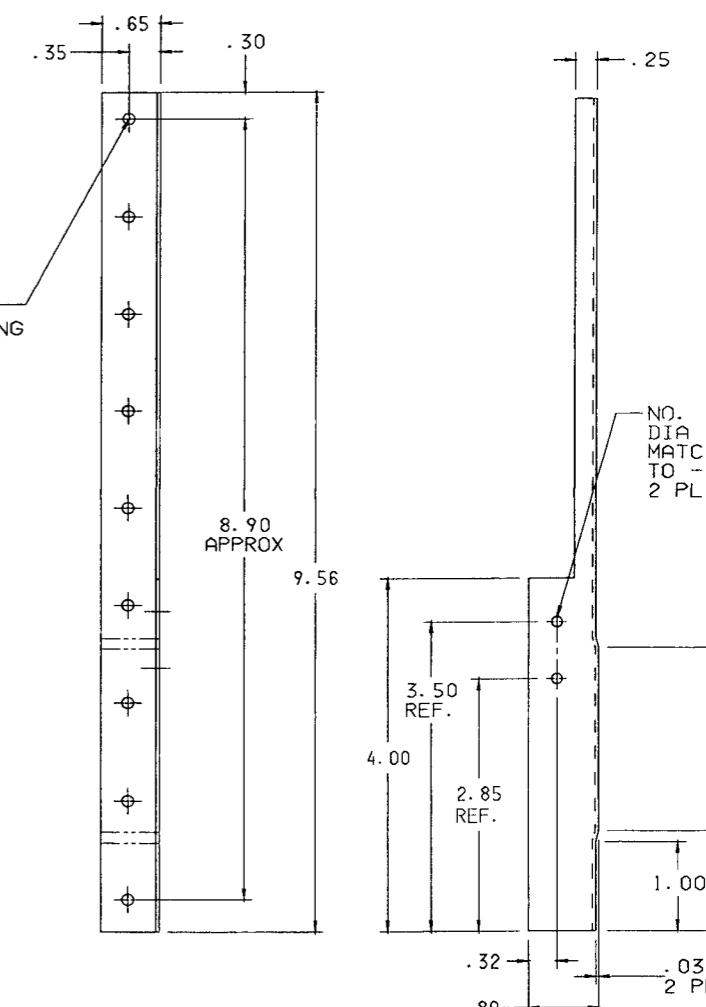


-27 SPACER 
MAT'L.: .050 THK 2024-T3
QQ-A-250/4



-21 TROUGH 
MAT'L: 3 PLY-BIDIRECTIONAL FIBERGLASS

NO 30 (.128) DIA HOLE
MATCH DRILL TO EXISTING
ACFT RIVET PATTERN



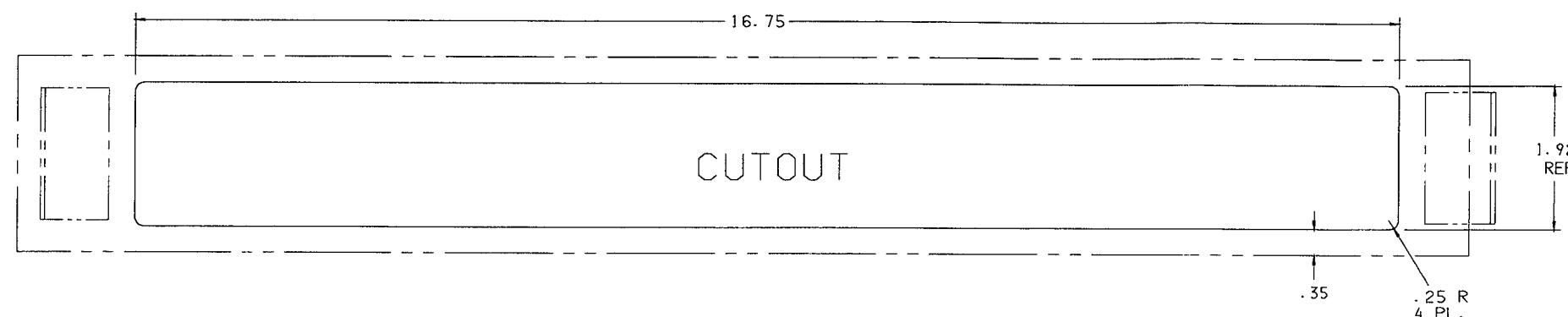
-17 STIFFENER 
MAT'L.: .040 THK 2024-T3
QQ-A-250/4

SIZE CODE IDENT NO. REV
D DSUV8 B23-13002 G
GEN/PUMP QUILL INSTALLATION SHEET 4 OF 5

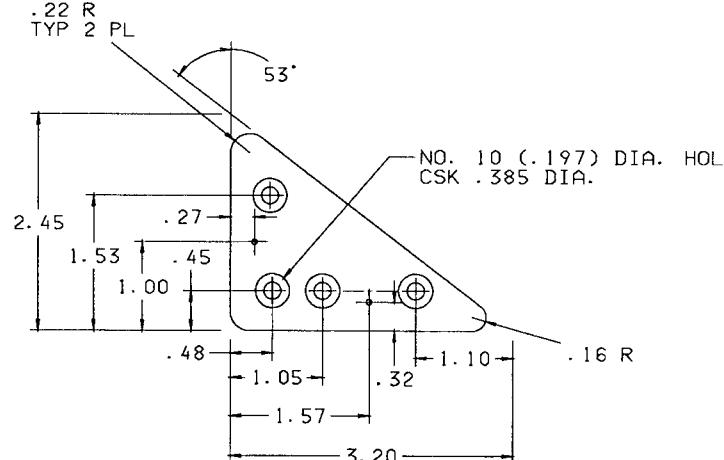
8 7 6 5 4 3 STC'd PRINT B2313002.04 ORIGINAL

STC SH7923SW STC SH7934SW

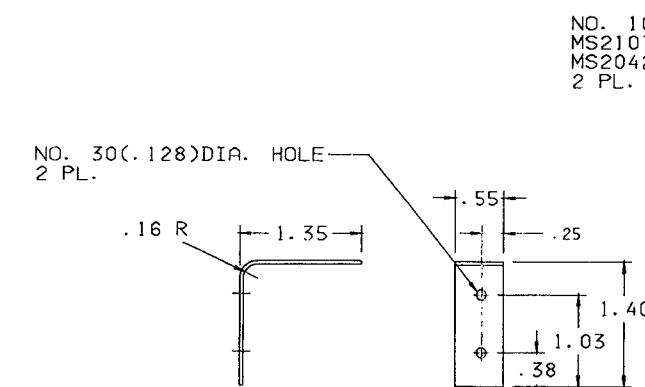
CUTOUT



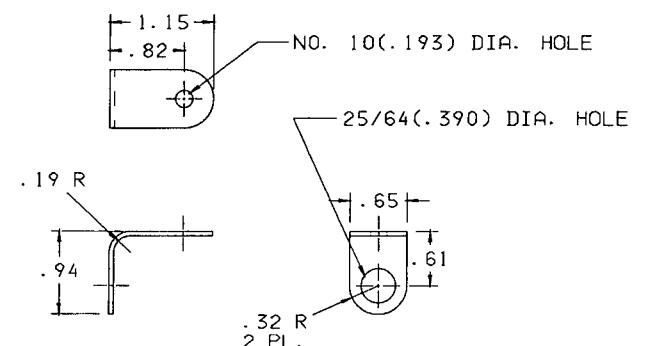
-23 MODIFICATION
400SG125-2 (AIRCRAFT PART CORP.)



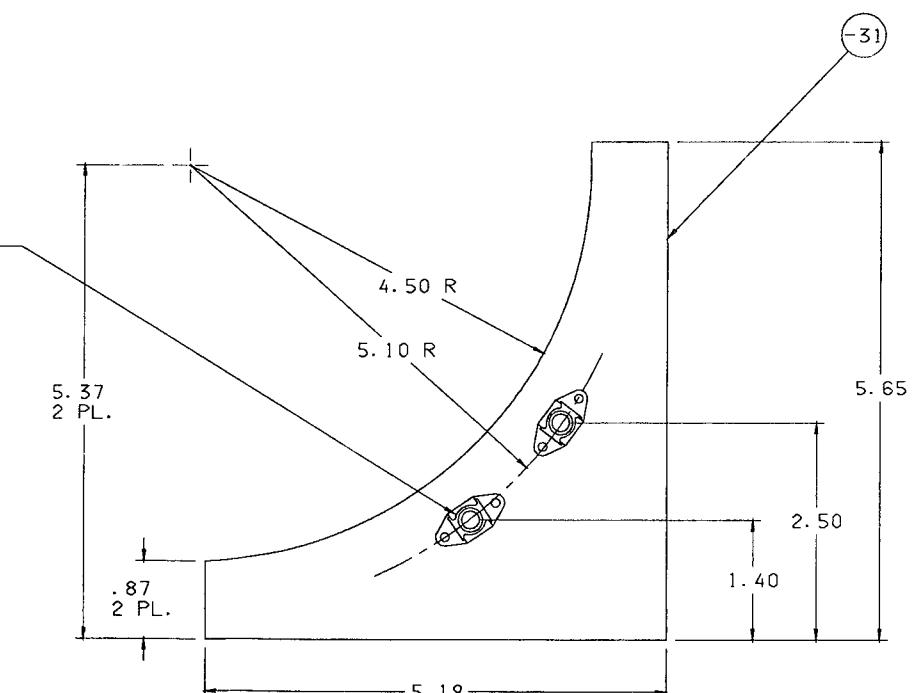
-41 SPLICE
MATL: .090 THK ALUM 2024-T3
QQ-A-250/4



-19 CLIP
MAT'L: .040 THK 2024-T3
QQ-A-250/4



-43 BRACKET
MAT'L: .050 THK 2024-T3
QQ-A-250/4



-37 ASSY
MAT'L: .050 THK 2024-T3
QQ-A-250/4

SIZE	CODE IDENT NO.	REV
D	DSUVV8	B23-13002
GEN/PUMP QUILL INSTALLATION		G
SHEET 5 OF 5		